

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014362**Date Inspected:** 14-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 7EW punch list Item 346. The weld designations reviewed are as follows:

1. FB003-067-005

7DW+7CW

Shield Metal Arc Welding (SMAW) base metal repair welding was performed on weld joint SEG037A+SEG039A located at cross beam side of segment. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and WR11052 procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at OBE8C bike path side of segment. Welder is identified as Mr. Han Xiaofeng (054467). ZPMC QC is identified as Li Yang. The

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welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR1525 procedure.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBW7A deck plate splice of segment. Welder is identified as Mr. Tian Zhaoquan (045246). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR1524 procedure.

Y Location of repairs areas by above noted welder (045246) is located at 4310, 5590, 6045 and 6620mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 003 located at OBW7A deck plate splice of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair-1 and CWR1524 procedure.

Y Location of repairs areas by above noted welder (045196) is located at 8440, 8940 and 9470mm.

7EW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at SEG041A counter weight side of segment. Welder is identified as Mr. Luo Xuanping (067610). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1 and WR12583 procedure.

7BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at SEG040E cross beam side of segment. Welder is identified as Mr. Zhao Guanglin (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 009 located at SEG037B counter weight side of segment. Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2211-Tc-U4b-FCM-1.

8BW+8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW8C counter weight side of segment. Welder is identified as Mr. Gang Huaigang (037840). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 002 located at OBW8C counter weight side of segment. Welder is identified as Mr. Zai Dawei (067942). ZPMC QC is identified as Wu Zhi Cheng. The

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welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at OBW8C counter weight side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at OBW8C cross beam side of segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at OBW8C cross beam side of segment. Welder is identified as Mr. Zhou Bing (067764). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations and indications are as followed:

7DW+7EW

1. Deck plate weld splice OBW7A-007, 008 and 009 temporary attachment areas.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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